

Split

Work Order ID 145204-2

Wednesday, May 04, 2016 12:39:37 PM

145204

Page 1

Item ID: D4961-041 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Tube Assembly
Start Date: 5/5/2016 Start Qty: ⁴5.00 *5* Cust Item ID:
Required Date: 5/9/2016 Req'd Qty: 5.00 *5* Customer:
Reference:

Approvals: Process Plan: dem 5/4 Date: 16/05/04 Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4961	B

110
110
Small Fab
Small Fab
Memo
1- Cut D4961-1 tube to size as per dwg
2- On one side of tube flare end as per dwg then slide sleeves and nuts, flare other side of tube as per dwg.

0.00

2.20

4 FF MAY 27 2016

120
120
QC
Quality Control

QC5- Inspect part completeness to step on W/O
Memo

0.00

0.10

(4) DAS
38
9-88
MAY 30 2016

130
130
Packaging
Packaging

Identify as per dwg & Stock Location: SK139
Memo

0.00

0.05

4 DAS
9-88
MAY 30 2016

97, 100, 101

102

103

104

105

106, 107, 108

109

110, 111, 112

113, 114, 115

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145204

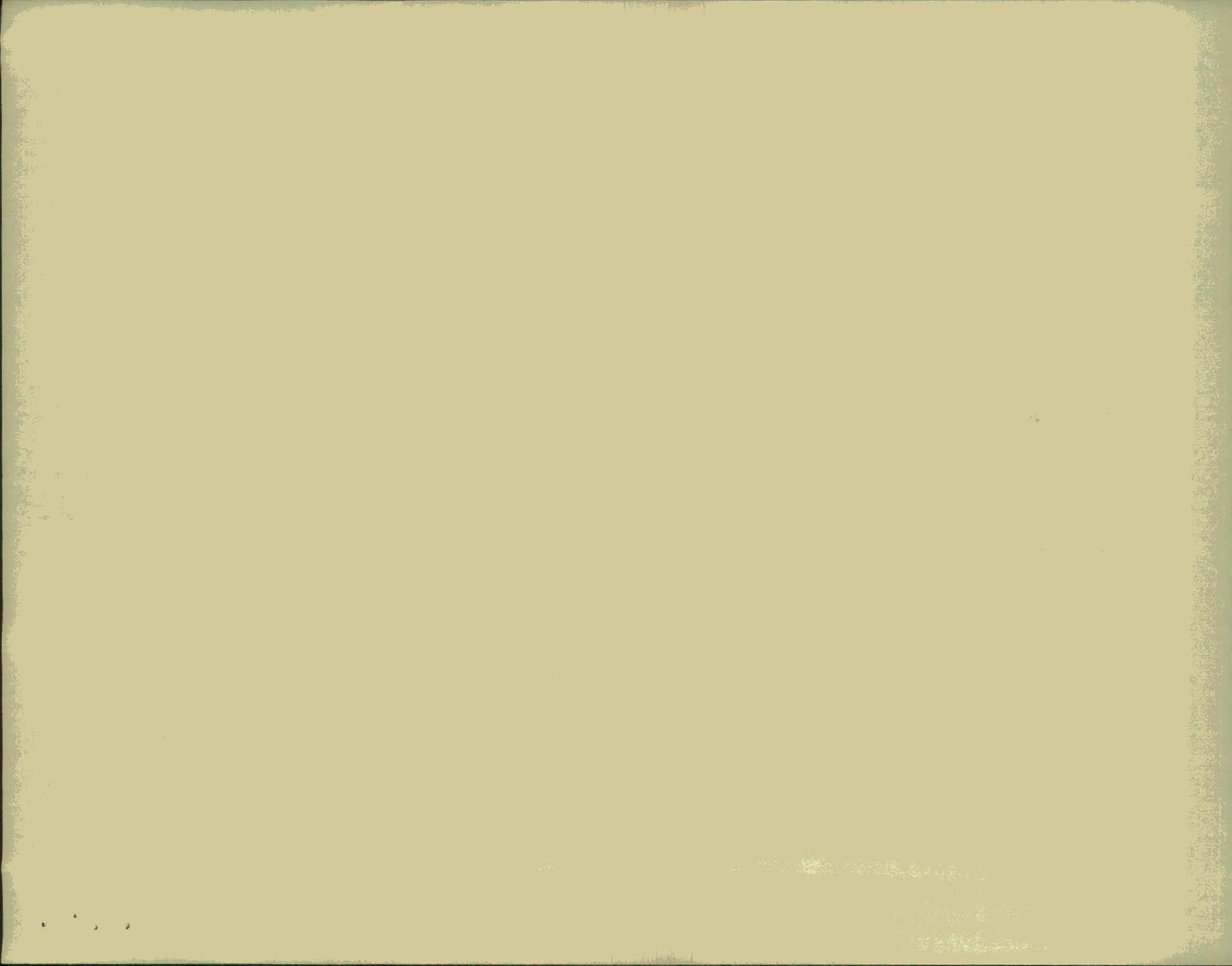
Page 2

Item ID: D4961-041 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Tube Assembly
Start Date: 5/5/2016 Start Qty: 5.00 *5* Cust Item ID:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC21- Final Inspection - Work Order Release	0.00							MAY 3 1 2016
140							MLJ		
QC	Memo	0.50							
Quality Control									

MLJ MAY 3 1 2016



Picklist Print

Page 1

Wednesday, May 04, 2016 12:39:42 PM

Work Order ID: 145204

145204

Parent Item: D4961-041

D4961-041

Parent Item Name: Tube Assembly

Start Date: 5/5/2016

Required Date: 5/9/2016

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP REV:A 13.10.22 NEW ISSUE DD VERF:JFS IPP
REV:B 15.02.18 AS PER DWG REV.B DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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AN818-L12J

Purchased

No

110

Each

14.000

2

10

AN818-L12J

Nut

**

FF may-05-2016

Location

Loc Qty

Loc Code

CCK006

6

m132803

6

ST325

8

m134257

8

M304TR0.750W.049

Purchased

No

110

F

256.525

0.7

3.684211

M304TR0 750W 049

304 RD Tube .750 x .049W

**

FF MAY 05 2016

Location

Loc Qty

Loc Code

GA002

250.9897742

M132270

0.00001

M133131

0.0007242

M133509

14.210211

M133700

8.85327

M133914

17.31816

M134138

2.610134

M134212

9.8302125

M134306

43.5001045

M134528

74.666948

M134604

80

MAT

5.5727347

M133400

5.5727347

~~3.684211~~ 1.4736844
~~9.424552~~ 2.2105266



Picklist Print

Page 2

Wednesday, May 04, 2016 12:39:42 PM

Work Order ID: 145204

145204

Parent Item: D4961-041

D4961-041

Parent Item Name: Tube Assembly

Start Date: 5/5/2016

Required Date: 5/9/2016

Start Qty: 5.00

Required Qty: 5.00

MS20819-12J

Purchased

No

110

Each

13.0000

2

10

MS20819-12J

FF may 5-2016

Sleeve

Location

Loc Qty

Loc Code

ST305

13

m133363

1

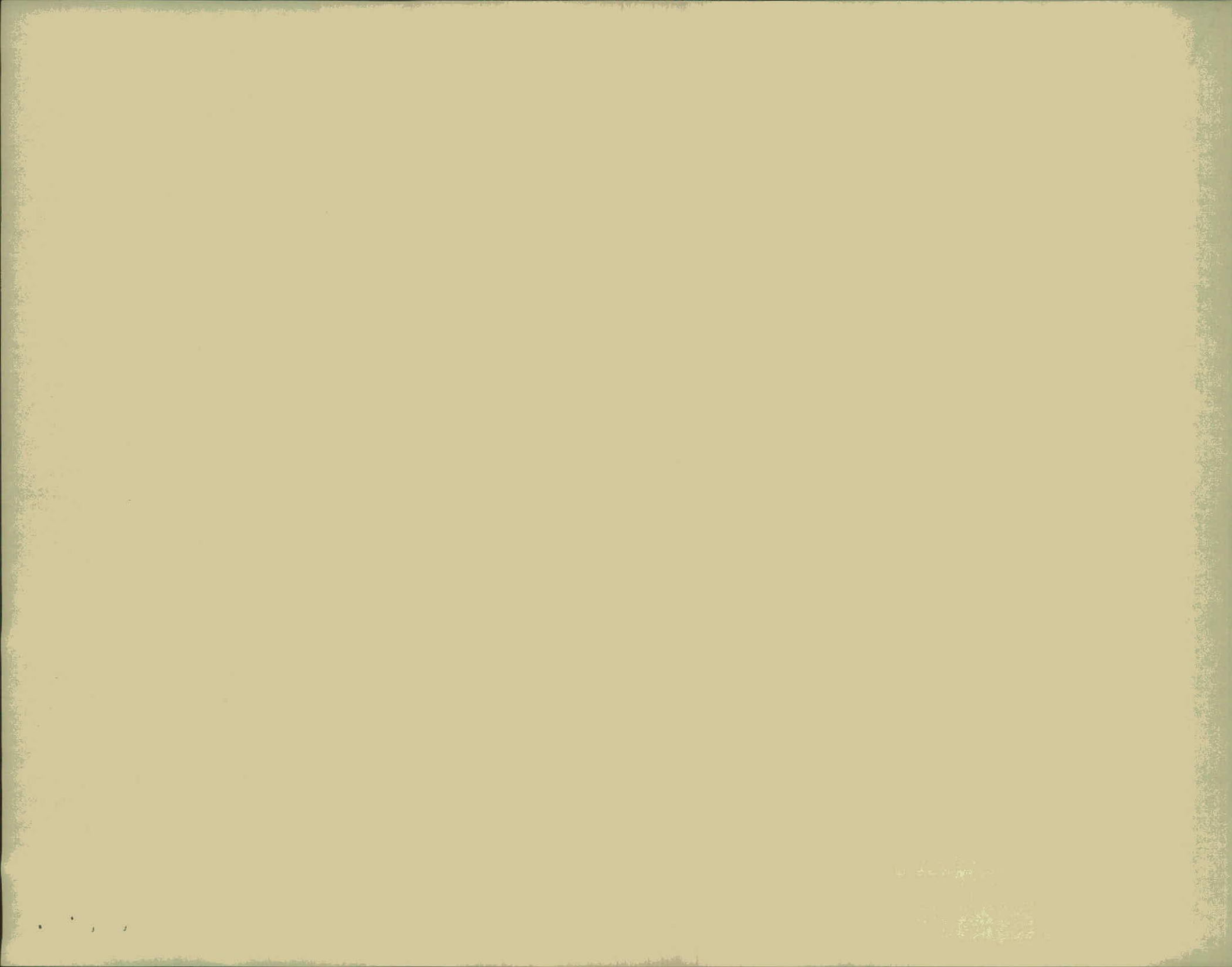
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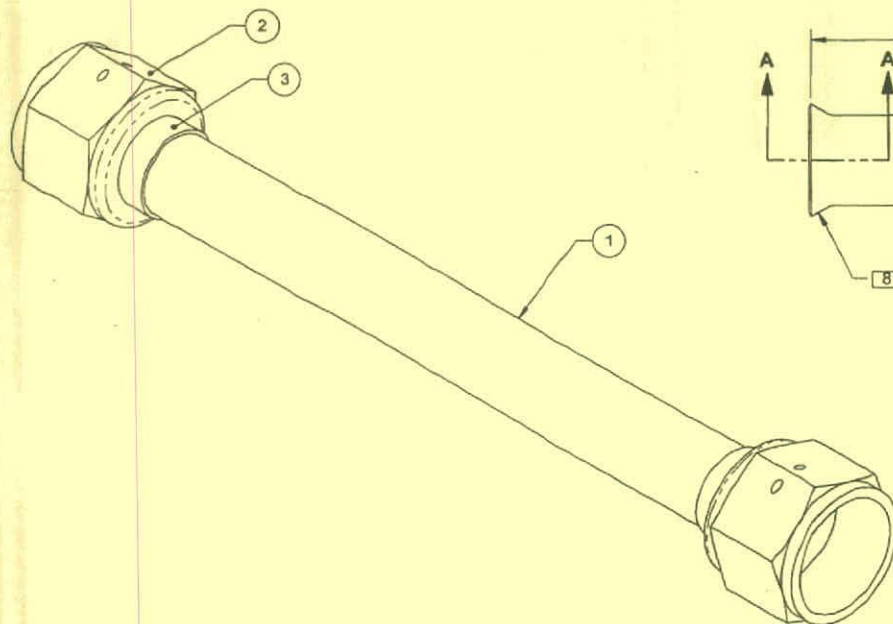
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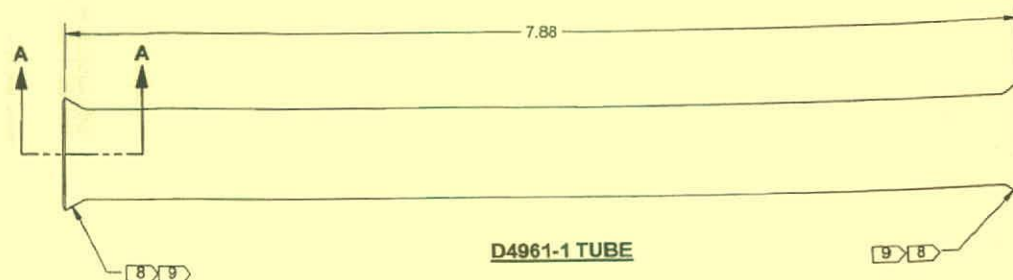
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2
7



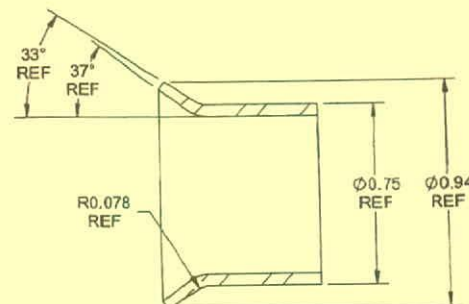
ITEM	QTY	P/N	DESCRIPTION
	X	D4961-041	TUBE ASSEMBLY
1	1	D4961-1	TUBE
2	2	AN818-L12J	NUT, TUBE COUPLING (DRILLED)
3	2	MS20819-12J	SLEEVE



D4961-041 TUBE ASSEMBLY



D4961-1 TUBE



SECTION A-A

RELEASED

2015 APR 30

97 ECH 15-527

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS ROUND TUBING, $\phi 0.750 \times 0.049$ WALL PER ASTM A213 OR ASME SA213 OR ASTM A269 (REF DART SPEC M304TR)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.59 lbs
- 8) FLARE TUBE PER MS33584
- 9) CLEAN INSIDE OF TUBE AFTER FLARING ENDS

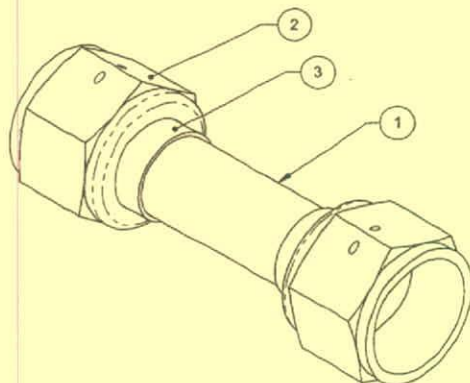
B	UPDATED BOM P/N AN818-L12J WAS AN818-12J. ADDED SHEET 2 (D4961-043)	AK	14.11.07
A	NEW ISSUE	VS	13.10.21
REV.	DESCRIPTION	BY	DATE
DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4961 TITLE TUBE ASSEMBLY THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN	AK		
CHECKED	RF		
MFG. APPR.	DD		
APPROVED	HS		
DE APPR.	DS	APPROVED DATE 14.11.07	
DATE	14.11.07		

w/o 145204

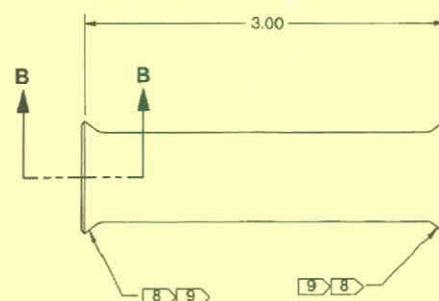
2m 16/05/04



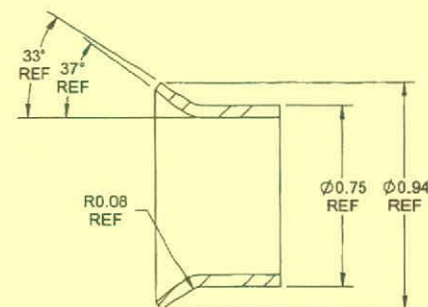
ITEM	QTY -043	P/N	DESCRIPTION
	X	D4961-043	TUBE ASSEMBLY
1	1	D4961-3	TUBE
2	2	AN818-L12J	NUT, TUBE COUPLING (DRILLED)
3	2	MS20819-12J	SLEEVE



D4961-043 TUBE ASSEMBLY



D4961-3 TUBE



SECTION B-B

RELEASED

2015 APR 30

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS ROUND TUBING, $\phi 0.750 \times 0.049$ WALL PER ASTM A213 OR ASME SA213 OR ASTM A269 (REF DART SPEC M304TR)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.44 lbs
- 8) FLARE TUBE PER MS33584
- 9) CLEAN INSIDE OF TUBE AFTER FLARING ENDS

APPROVED

DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AK		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	DD	D4961	SHEET 2 OF 2
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	TUBE ASSEMBLY	NTS
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